



Dart Aerospace Ltd.
1270 Aberdeen / St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 169948



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/4/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

AIRBUS

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/24/18	1/24/18	0.00	0.00	Start Up Large Fab-4		SL 1/16/18
110	Large Fab	10 pcs	1/25/18	1/25/18	0.00	10.00	Large Fab 2		SL 1/17/18
120	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC9		CL
130	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC5		CL
140	HandFinish	10 pcs	1/25/18	1/25/18	0.00	1.87	HandFinish1		2018/01/18 J
150	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs	1/25/18	1/25/18	0.00	10.00	Large Fab 2		DAS 1/25/18
190	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC10		38 DAS
200	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC5		38
210	HandFinish	10 pcs	1/25/18	1/25/18	0.00	1.87	HandFinish1		2018/01/25 J
220	Powdercoat	10 pcs	1/25/18	1/25/18	0.00	2.98	Powdercoat1		BR 18-01-29
230	HandFinish	10 pcs	1/26/18	1/26/18	0.00	1.87	HandFinish3		BEB 18-01-29
240	QC	10 pcs	1/26/18	1/26/18	0.00	0.00	QC3		11
250	Packaging	10 pcs	1/26/18	1/26/18	0.00	0.00	Packaging1-3		JAN 29 2018 W.K.
260	QC	10 pcs	1/26/18	1/26/18	0.00	0.00	QC4	D3335-1	7.10
265	DC	10 pcs	1/26/18	1/26/18	0.00	0.00	DC		
270	Packaging	10 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-1		DAS
280	QC21-FG	10 Ea	1/26/18	1/26/18	0.00	0.00	QC21		21 FEB 07 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 12:00 OVEN TEMPERATURE: 320 FINISH TIME: 12:30

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

Wing with M18711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
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Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

-Start up Operation

180-Large Fab

250-Packaging

✓ D3067-1 S030168	10	18	0	0
✓ D3219-1 S026617	20	54	0	0
✓ S032336 → D3272-1 S031748 ✓	10	0	0	0
D3065-041 S030236	10	14	0	0
✓ D3066-1 S012395	20	90	0	0
✓ D3067-1 S030168	10	18	0	0
✓ S016823 → MS20600-AD4W4	160	1,447	0	0
AN3-35A	20	268	0	0
AN4-13A	80	1,299	0	0
AN5-36A	20	194	0	0
D2230-3	40	179	0	0
D2618	20	190	0	0
D2856-400-720	120	155	0	0
D3235-1	20	67	0	0
D3278-041	10	23	0	0
MS21042L3	20	3,336	0	0
MS21042L4	80	3,684	0	0
MS21042L5	20	759	0	0
NAS1149D0363J	40	4,434	0	0
NAS1149D0463J	160	5,772	0	0
NAS1149D0563J	40	1,319	0	0

360 320

Part Specifications

Specifications could not be found.

Plex 1/4/18 8:46 AM dart.poulin.mario

~~S031748~~



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CANADA
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Helix Access - Step RH - High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350-591-312

Original Serial #: S033003

Revision:

Operation: Start up Operation 01/17/18

Change No: CHG002

Job No: 169948

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only ☐



Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date: _____	Step #: _____	QTY Effective: _____	MRB (QSI042) Approval
Disposition			Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval
FAULT CATEGORY			
☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	
☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	
☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	
☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	
☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	
☐ Contamination	☐ Out of Sequence	☐ Part Moved	
☐ Countersink	☐ Off-set	☐ Drawing	
☐ Cut Too Short	☐ Misabeled	☐ Finish	
☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	
☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	



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Master Unit 000258

Containers on Master Unit 000258				
Serial No	Part No	Customer Part No	Status	Quantity
S014738	AN3-35A		Allocated	2
S037098	AN3-35A		Allocated	18
S037086	AN4-13A		Allocated	80
S037082	AN5-36A	AN5-36A	Allocated	20
S037063	D2230-3	D2230-3	Allocated	40
S037055	D2618	D2618	Allocated	20
S037053	D2856-400-720	D2856-400-720	Allocated	12
S037074	D2856-400-720	D2856-400-720	Allocated	8
S037048	D3278-041	D3278-041	Allocated	10
S037044	MS21042L3	MS21042L3	Allocated	20
S037036	MS21042L4	MS21042L4	Allocated	80
S037030	MS21042L5		Allocated	20
S037027	NAS1149D0363J	NAS1149D0363J	Allocated	40
S037017	NAS1149D0463J	NAS1149D0463J	Allocated	160
S036994	NAS1149D0563J	NAS1149D0563J	Allocated	40

~~S037017~~
~~S037017~~
 S007814 D3235-1 S037239x1 Allocated 14
 S038833y19

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
8	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.